

# Work Order ID 55112

January 6, 2010 2:13:30 PM



Page 1

Item ID: D3822-3KIV

Accept



Setup

Start



Revision ID:

Item Name: Vertical Tunnel, Aft Center-Ivory

Stop



Start Date: 1/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_ Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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100



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB  
10/6/27  
X1

110



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA027 using tool DT9072  
Dwg Rev: C  
Folio Rev: A

BB  
10/6/27  
X1

**Work Order ID 55112**

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Page 2

**Item ID:** D3822-3KIV**Accept****Setup****Start****Revision ID:****Item Name:** Vertical Tunnel, Aft Center-Ivory**Stop****Start Date:** 1/06/10 **Start Qty:** 1.00**Cust Item ID:****Required Date:** 1/11/10 **Req'd Qty:** 1.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run****Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/  
Work Center ID**

120



QC

Quality Control

**Operation  
Description**

QC2- Inspect parts off machine FAI/FAIB

**Set Up/  
Run Hours**

0.00

**Draw  
Number**Draw  
Rev.**Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

BB  
10/01/27  
(X1)

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

**Memo**

0.00

BL 10/01/27  
(X1)

140



HandThermo

Hand Finishing Thermoforming

**Memo**

0.00

1-Trim to finished dimensions as per Dwg

0.00

BL 10/01/27  
KL

**Work Order ID 55112**

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Page 3

Item ID: D3822-3KIV

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel, Aft Center-Ivory

Stop



Start Date: 1/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
Description

150



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

160



QC5- Inspect part completeness to step on W/O

QC

Quality Control

2010/01/25

④

170

Identify as per dwg & Stock Location: Q/A 10700 JAN

Packaging

Packaging

Memo

Q/A 10700 JAN

10-1-28

Q/S

**Work Order ID 55112**

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January 6, 2010 2:13:31 PM

Item ID: D3822-3KIV

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel, Aft Center-Ivory

Stop



Start Date: 1/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

180



QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/2010  
MF  
10-1-28

007005an

# Picklist Print

January 6, 2010 2:13:29 PM

Page 1

Work Order ID: 55112



Parent Item: D3822-3KIV



Parent Item Name: Vertical Tunnel, Aft Center-Ivory

Start Date: 1/06/10

Required Date: 1/11/10

Comments: Est Rev:C Add Colour Code 09-06-02 DL

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased		No		100	sf	790.9390	5.2526			

6185 KYDEX .080"



## Warehouse

## Location

Main Warehouse

MAT	790.9390153
109703	790.939015

## Loc Qty

## Loc Code

7.8 sq ft

BB  
10/01/27  
XL

DART AEROSPACE LTD	Work Order:	5511V
Description: Vertical Tunnel, Aft Center	Part Number:	D3822-3KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

## **THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

**Measured by**

Dt.

Date:

10/01/28

## TRIMMING SECTION

**Measured by:**

Dr.

**Date:**

10/01/27

**Audited by:**

3

Date: \_\_\_\_\_

100/27.

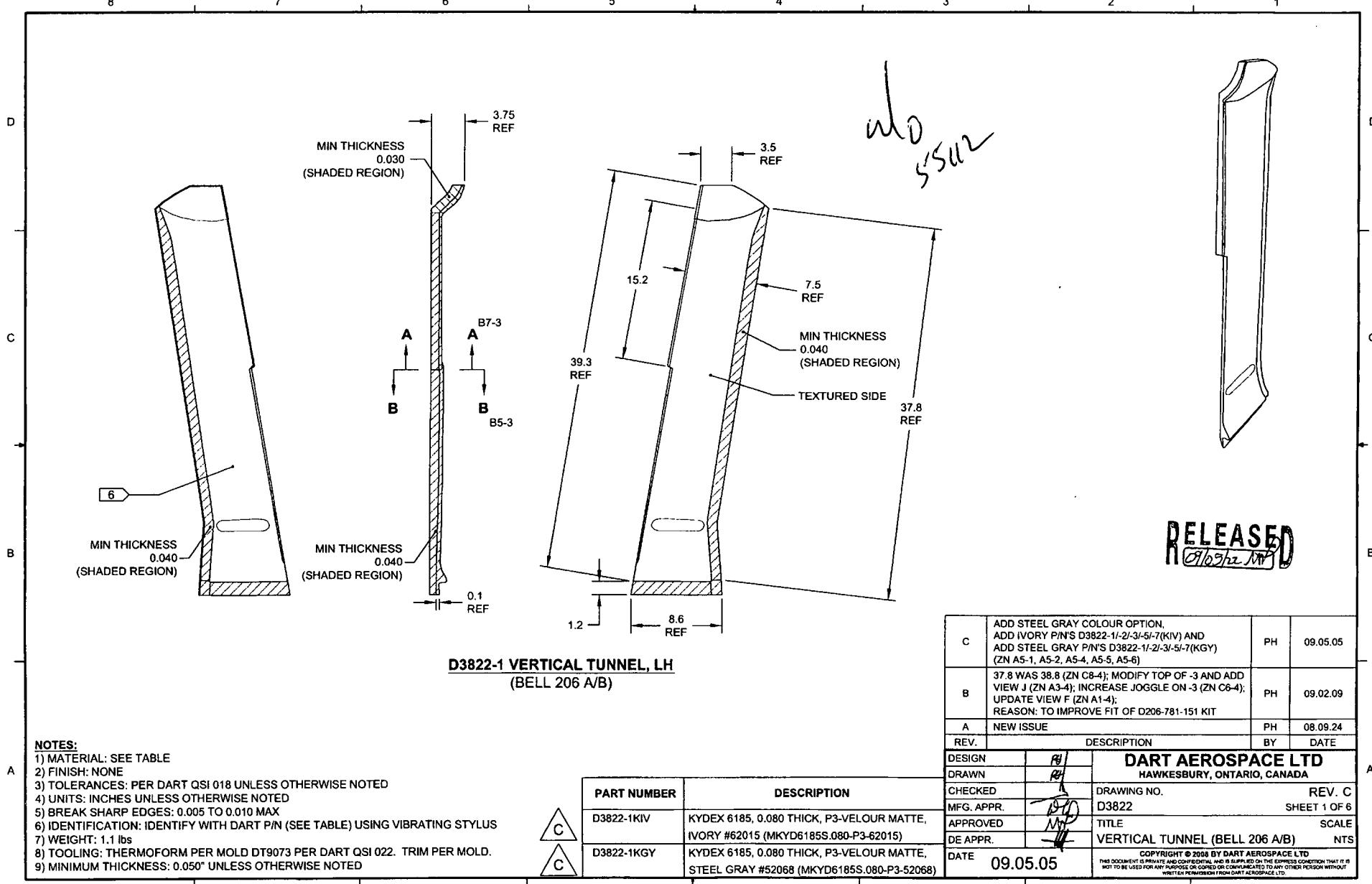
### Prototype Approval:

NA

Date: \_\_\_\_\_

N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	MM



**NOTES:**

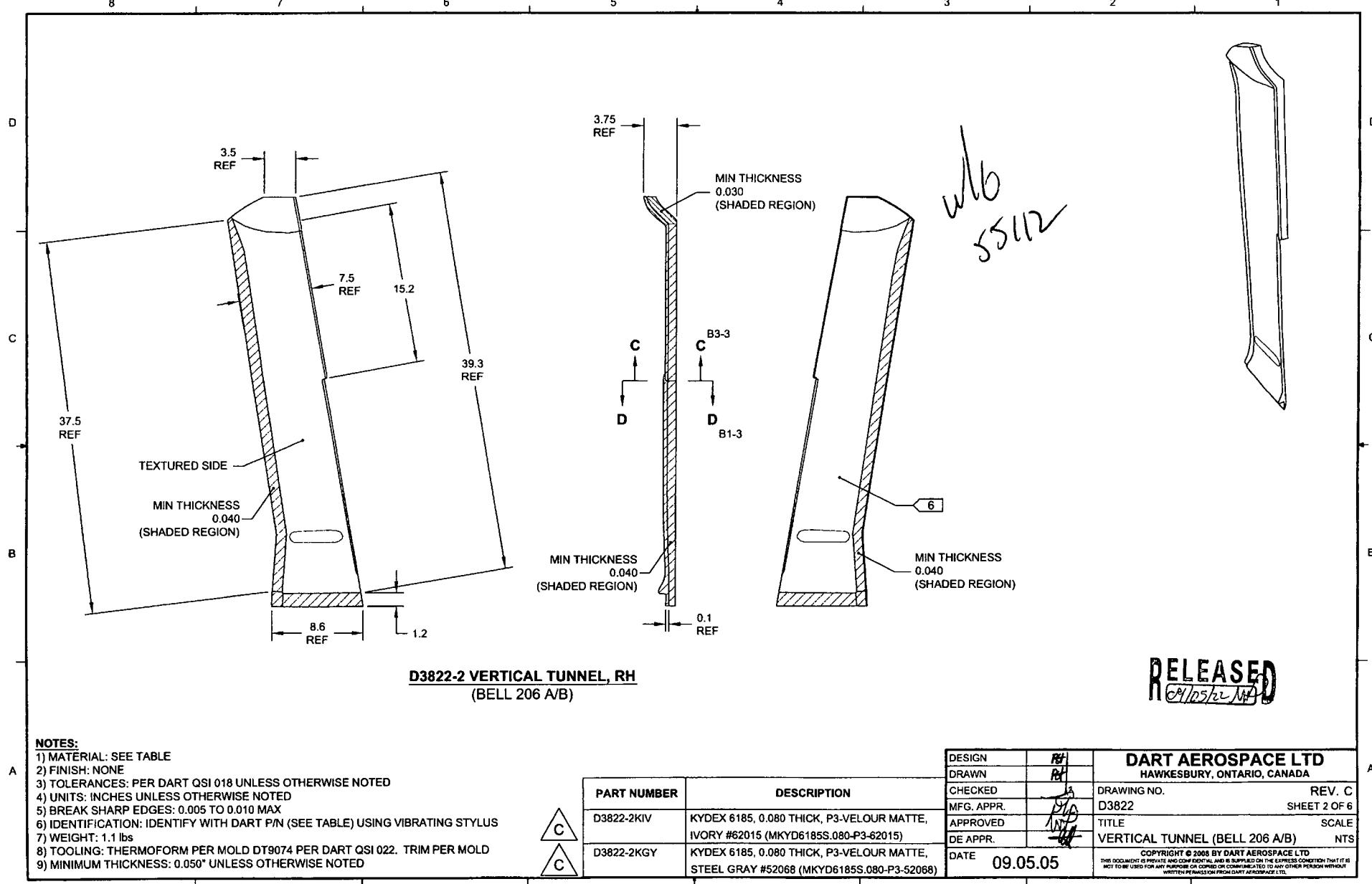
- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

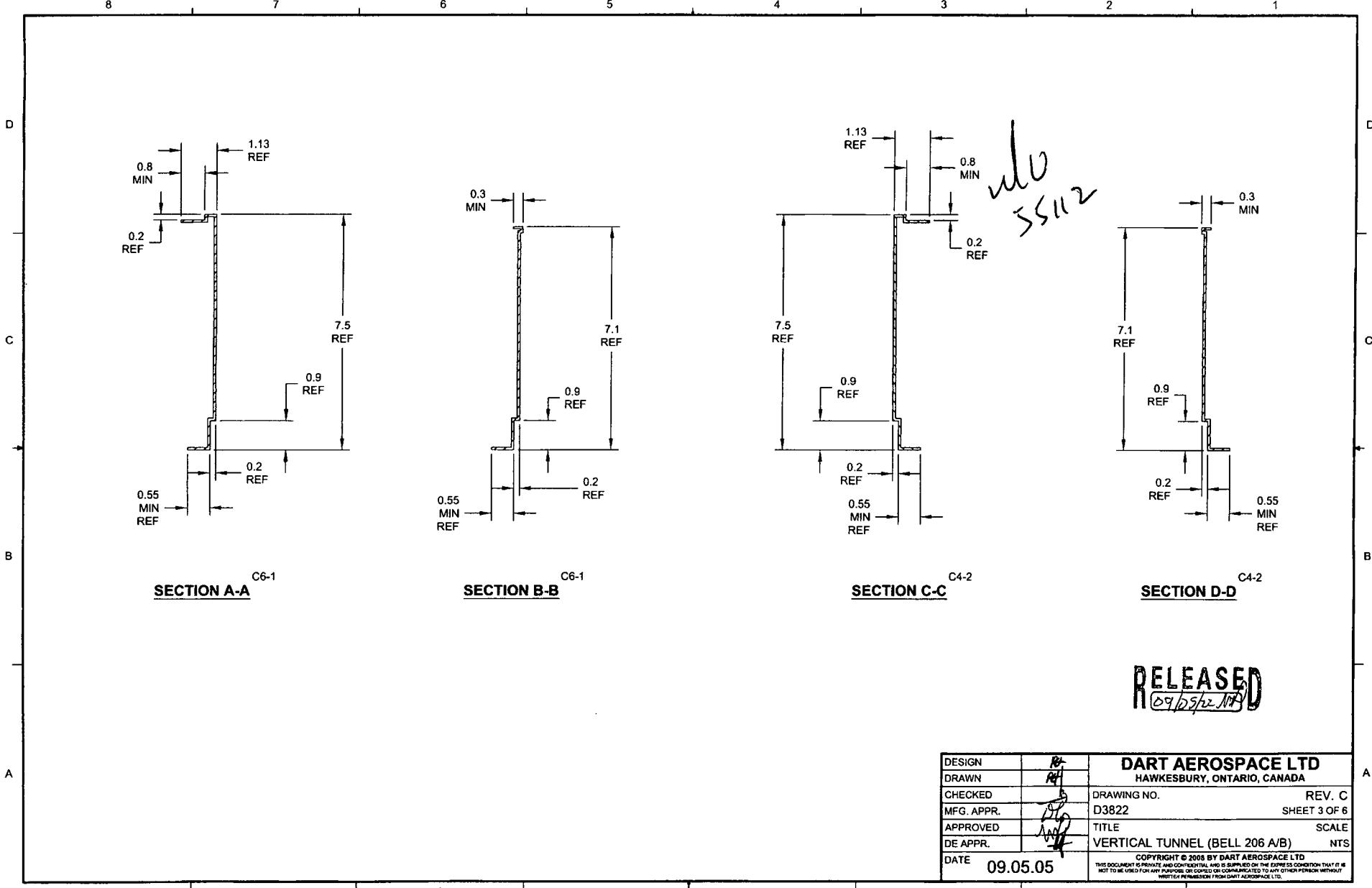
c  
c

PART NUMBER	DESCRIPTION
D3822-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

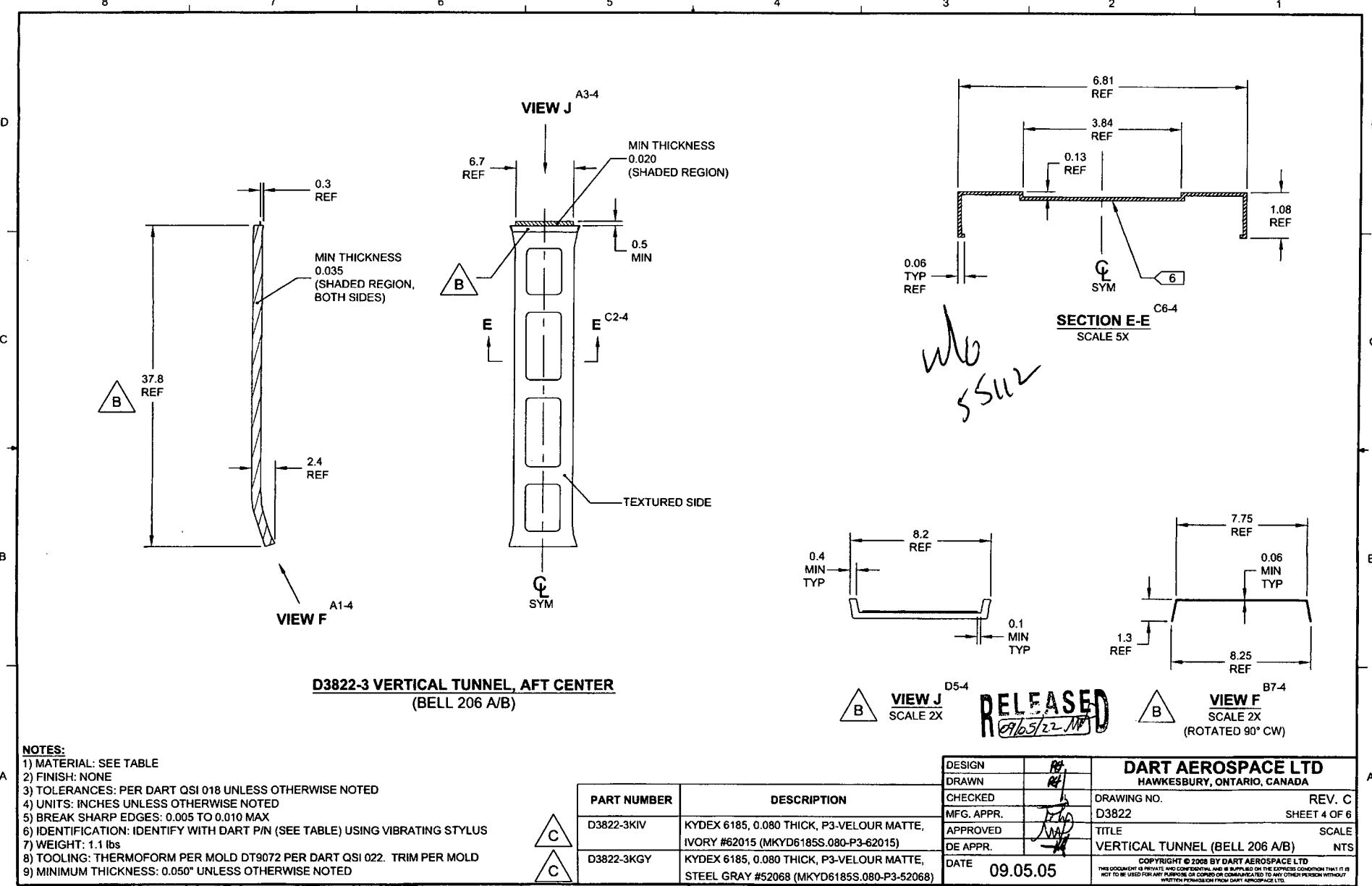
C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3822-1-2/3-5/7(KVG) AND ADD STEEL GRAY P/N'S D3822-1/2-3/5-7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)	PH	09.05.05
	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C6-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT		PH
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RE</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>RE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>D3822</i>	D3822	SHEET 1 OF 6
APPROVED	<i>MAP</i>	TITLE	SCALE
DE APPR.	<i>MAP</i>	VERTICAL TUNNEL (BELL 206 A/B)	NTS
DATE	09.05.05	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	

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DESIGN	R	DART AEROSPACE LTD
DRAWN	RH	HAWKSLEY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3822 SHEET 3 OF 6
APPROVED		TITLE SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND RESTRICTED. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



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2

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D

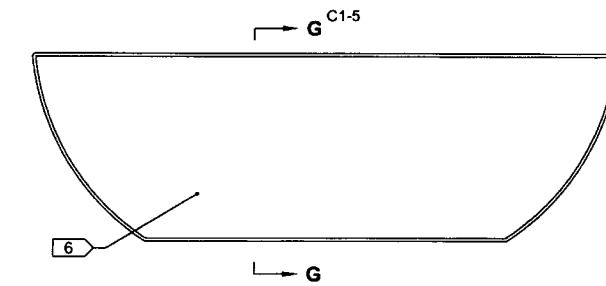
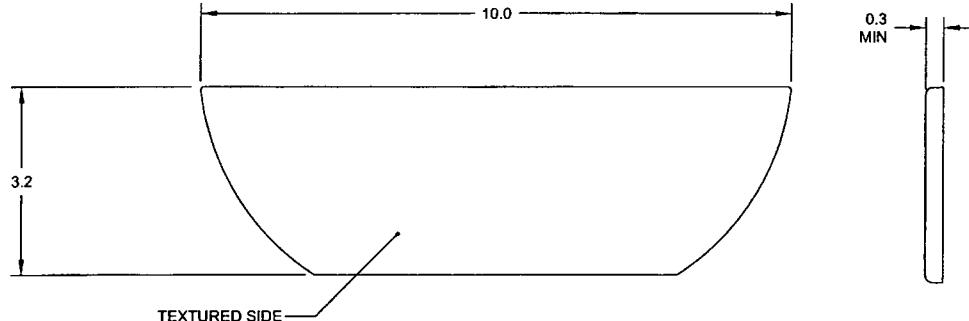
D

C

C

B

B



MIN THICKNESS  
0.060  
TYP

MIN THICKNESS  
0.040

MIN THICKNESS  
0.040

SECTION G-G

W055112

D3822-5 VERTICAL TUNNEL, TOP  
(BELL 206 A/B)

RELEASED  
05/05/05

**A NOTES:**

- 1) MATERIAL: SEE TABLE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.12 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9078 PER DART QSI 022

C  
C

		DESIGN DRAWN	REV. C	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
		CHECKED MFG. APPR.	REV. C	DRAWING NO. D3822
		APPROVED DE APPR.	SCALE NTS	TITLE VERTICAL TUNNEL (BELL 206 A/B)
			09.05.05	Copyright © 2008 by DART AEROSPACE LTD This document is private and confidential and is supplied only under express condition that it is not to be used for any other purpose or disclosed to any other person without written permission from DART AEROSPACE LTD.

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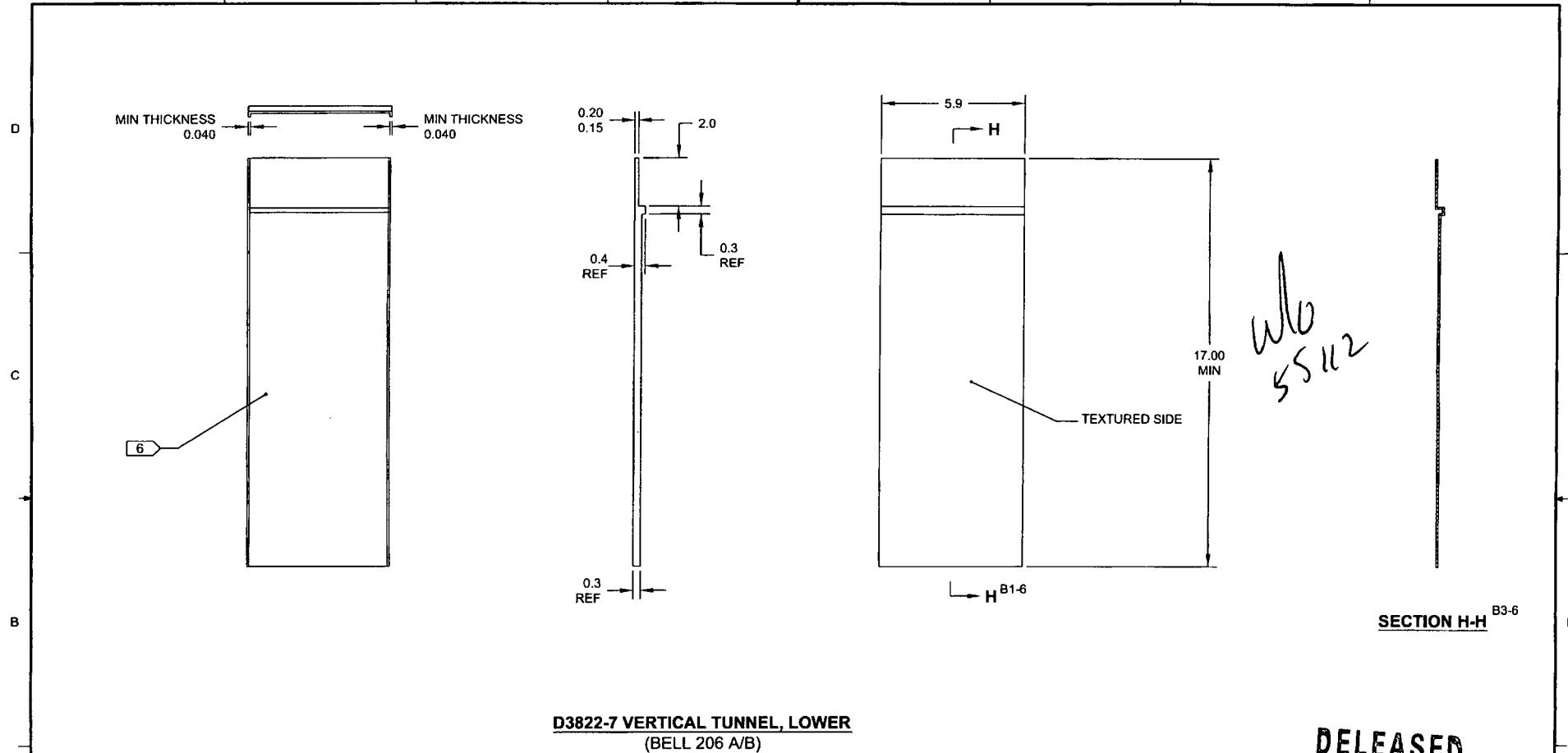
3

2

1

A

8 7 6 5 4 3 2 1



**D3822-7 VERTICAL TUNNEL, LOWER**  
(BELL 206 A/B)

RELEASED  
09/05/22 M

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION	DESIGN	DRAWN	DART AEROSPACE LTD	
		CHECKED	MFG. APPR.	DRAWING NO.	REV. C
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)			D3822	SHEET 6 OF 6
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)	APPROVED JAN	DE APPR.	TITLE VERTICAL TUNNEL (BELL 206 A/B)	SCALE NTS

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8 7 6 5 4 3 2 1

A